

Date: Tuesday, 8/1/2006 11:31:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER AFT SADDLE
Job Number	: 28082		
Estimate Number	: 11080		
P.O. Number	: N/A	Part Number	: D5955
This Issue	: 8/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D5955 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: N/A
Written By	:	Due Date	: 8/31/2006
Checked & Approved By	: <u>06.08.01</u>	Qty:	4 Um: Each
Comment	: Est Rev:E Re-Format 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101013

Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: 025356

X4

J.G

06/11/10

2.0

HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

BG

2-Machine Keyway PTO

06/11/10
J.G

3-Deburr & Tumble

06/11/10 X4

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

06/11/11

X4

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/11/12

5.0

HAND FINISHING1


HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

J.L 06/11/13 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED (V) SIMILAR TO DESG 1 SEE ATTACHED	PH 06-01.03				 06.11.03

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/11/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:31:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 28082

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M. 06/11/15 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 11 15 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

RV 4/4/16 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/16 (4)

Job Completion



C Loc 11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28082
Description: Outer Aft Saddle	Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.751	1.751		
C	5.245	5.255		5.246	5.248	5.250	5.249		
D	6.995	7.005		7.000	6.999	7.001	6.999		
E	5.745	5.755		5.747	5.747	5.751	5.749		
F	4.745	4.755		4.748	4.750	4.749	4.746		
G	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
H	1.522	1.532		1.528	1.528	1.527	1.527		
I	3.048	3.058		3.054	3.053	3.055	3.054		
J	4.575	4.585		4.580	4.583	4.578	4.581		
K	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
L	0.240	0.260		0.253	0.256	0.256	0.255		
M	0.490	0.510		0.500	0.501	0.501	0.501		
N	0.240	0.260		0.254	0.256	0.258	0.256		
O	7.990	8.010		8.006	8.005	8.006	8.006		
P	0.240	0.260		0.258	0.256	0.257	0.256		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.500	0.502	0.498	0.497		
T	1.625	1.645		1.627	1.633	1.633	1.633		
U	2.000	2.020		2.000	2.005	2.005	2.005		
V	0.023	0.043		0.030	0.030	0.030	0.03		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CP
Date:	06/11/11

Audited by:	J.L
Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	



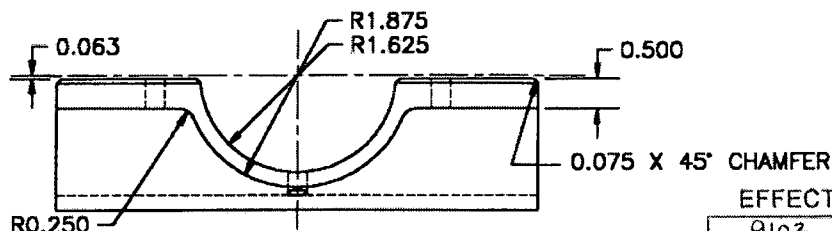
TOP 0505



DESIGN BW	DRAWN BY [Signature]	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED BW	DRAWING NO. D5955	REV. A SHEET 1 OF 1
DATE 97.05.06		TITLE OUTER AFT SADDLE	SCALE

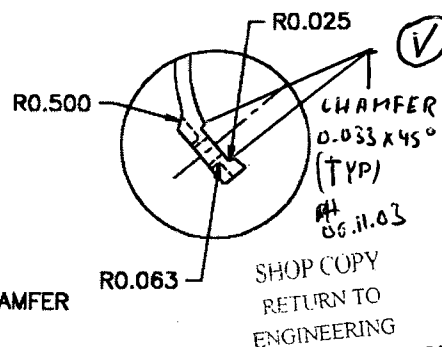
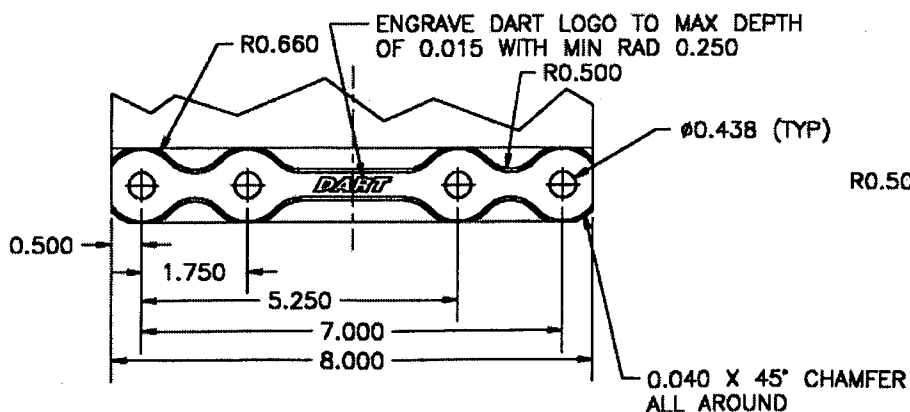
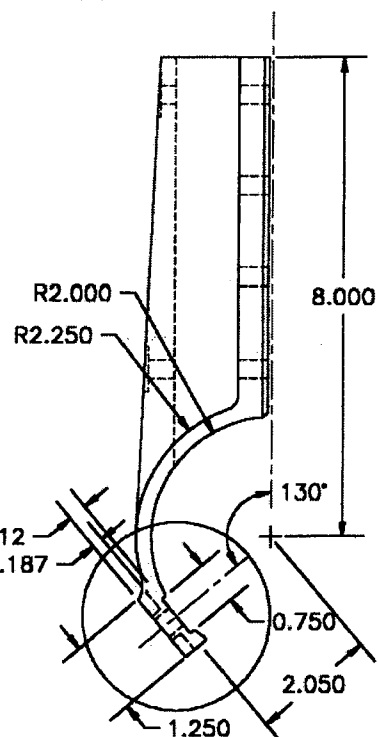
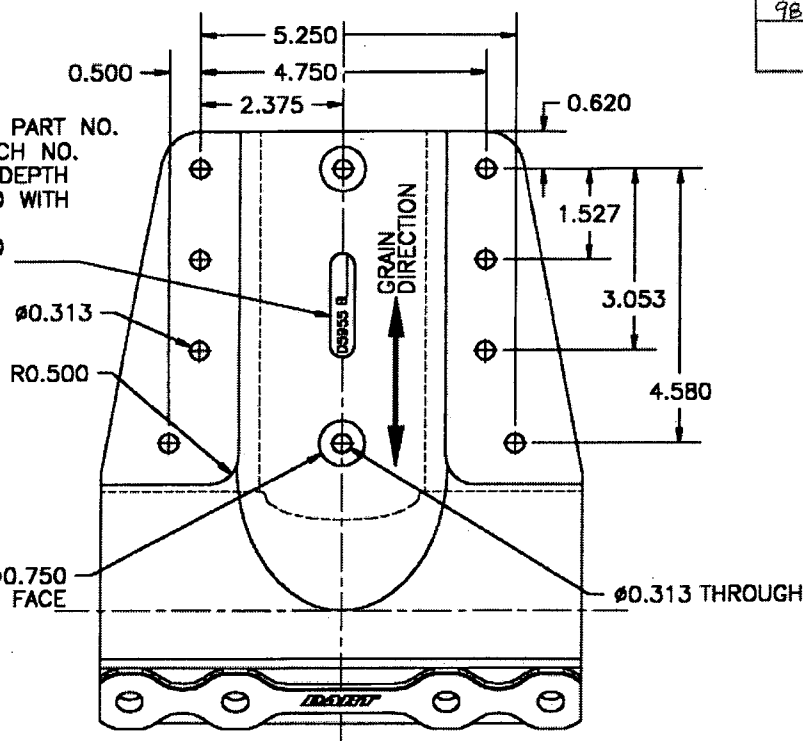
MATERIAL: ~~7075-T651~~ OR 7075-T7351 QQ-A-250/12
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2
BREAK ALL SHARP EDGES 0.010 TO 0.020

RELEASED
97/05/14 DS



EFFECTIVE	DEOs
9102 98/05/04 DS	9079 98/06/22 DS

ENGRAVE PART NO.
AND BATCH NO.
TO MAX DEPTH
OF 0.010 WITH
MIN RAD
OF 0.010



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WITHOUT NOTICE
WORK ORDER
NO. 28082

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 10:22 AM
To: 'Peter Hum'
Subject: RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, November 02, 2006 2:33 PM
To: 'David Shepherd'
Subject: D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

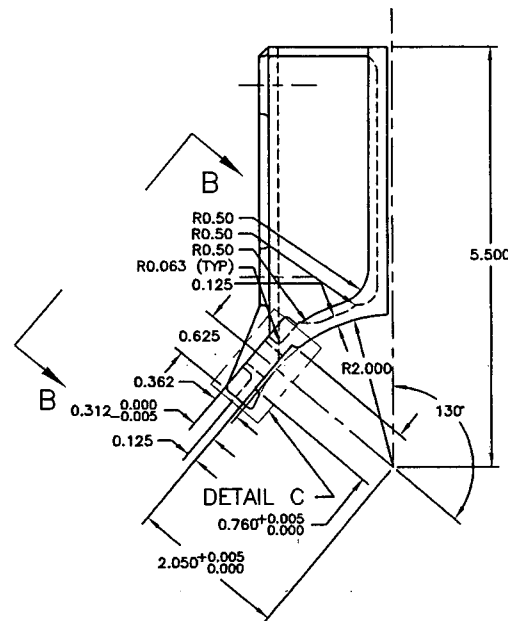
Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

Peter

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

03/11/2006



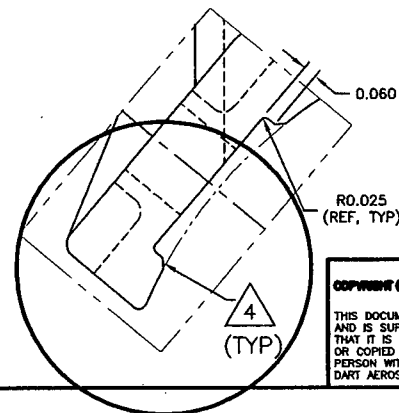
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

REFERENCE ONLY

REFERENCE ONLY



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	APPROVED	DART HAWKESBURY, ONTARIO, CANADA
DATE	05.07.13	DRAWING NO. D2574
TITLE	INNER AFT SADDLE	REV. E SHEET 1 OF 1
SCALE	2:3	